

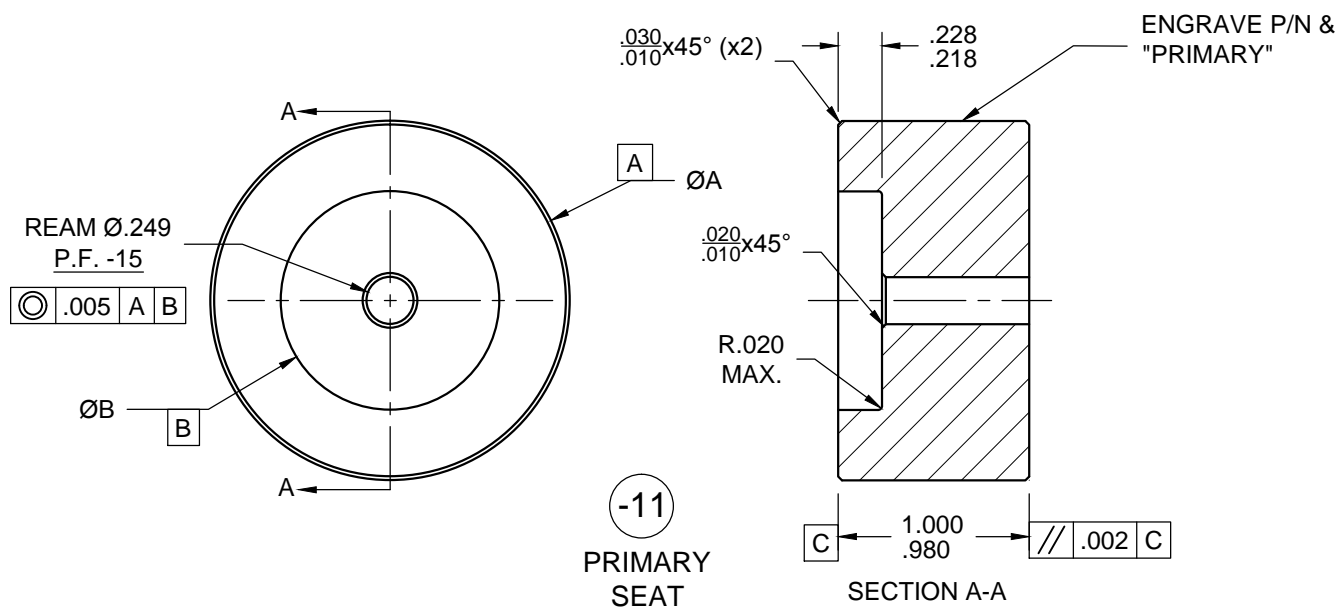
[illegible]

1. BREAK ALL SHARP CORNERS (.015/.03).


 RED BARN MACHINE	
TITLE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACBIOFA BEARINGS; LOCATING PIN	
DWG NO.	REV 1
TOOL# (see chart)-15	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING SEE Pg. 1
SCALE NTS	DATE 6-26-08 SHEET 9 of 9

 RED BARN MACHINE	
TITLE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10FA BEARINGS; SECONDARY SEAT	
DWG NO.	REV 1
TOOL # (see chart)-13	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-26-08 SHEET 8 of 9

[illegible]

NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).


 RED BARN MACHINE			
TITLE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10FA BEARINGS; PRIMARY SEAT			
DWG NO.		REV 1	
TOOL # (see chart)-11		PERRITT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX \pm .005 .XX \pm .01 .X \pm .1 FRACTIONS \pm 1/32 ANGLES \pm 5°		DRAWN BY: APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1	
SCALE NTS	DATE 6-26-08	SHEET 7	of 9

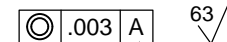
Technical drawing of a hole with a hole feature control symbol. The symbol consists of a circle with a horizontal line through its center. An arrow points from the symbol to the hole. The symbol is labeled with the diameter symbol \varnothing and the letter A.

Technical drawing of a shaft with the following dimensions and tolerances:


- Left end chamfer: $\frac{.020}{.010} \times 45^\circ$
- Left end fillet: R.015 MIN.
- Top fillet: $\frac{.322}{.302}$
- Dimension C: Distance from the left end to the start of the main shaft section.
- Dimension D: Total length of the shaft.
- Right end step: .08
- Right end hole: $\varnothing B$
- Right end hole tolerance: $\frac{\text{Hole}}{.003}$
- Right end hole position: A

1. BREAK ALL SHARP CORNERS (.015/.03).


 RED BARN MACHINE			
TITLE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10FA BEARINGS; PIN			
DWG NO. TOOL# (see chart)-9			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE NTS	DATE 6-26-08	SHEET 6	of 9



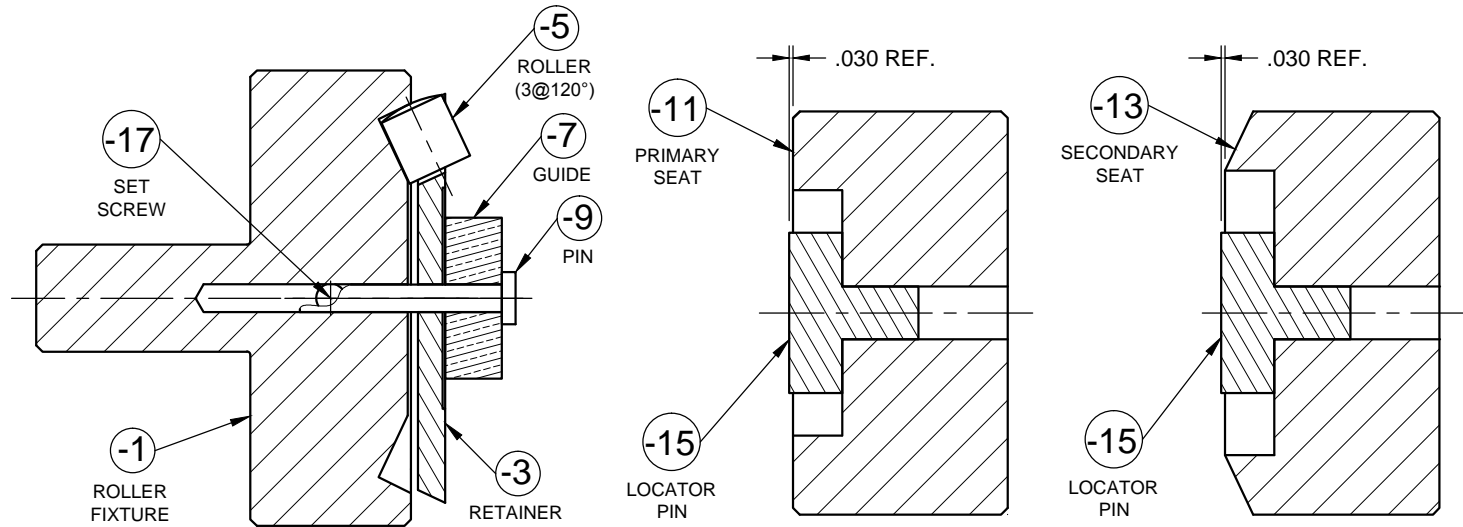
GUIDE

 RED BARN MACHINE	
TITLE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10FA BEARINGS; GUIDE	
DWG NO.	REV 1
TOOL# (see chart)-7	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING SEE Pg. 1
SCALE NTS	DATE 6-26-98 SHEET 5 of 9



 RED BARN MACHINE			
TITLE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10FA BEARINGS; ROLLER			
DWG NO. TOOL# (see chart)-5			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1	
SCALE NTS	DATE 6-26-08	SHEET 4	of 9

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGED -5 ROLLER RADUIS FROM .005 - .010, TO .015 - .020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW



DRILL PRESS TRI-ROLLER SWAGING TOOL ASSEMBLY

NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
BACB10FA10	KSTFA10

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	1	SECONDARY SEAT	SEE CHART	8
		-15	2	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S


RED BARN MACHINE

TITLE KSTFA SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10FA BEARINGS

DWG NO. SEE CHART ABOVE FOR TOOL No. 1 REV 1

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS		HEAT TREAT LISTED PER ITEM	
.XXX ± .005		FINISH LISTED PER ITEM	
.XX ± .01		USED ON BEARING	
.X ± .1		SEE ABOVE	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SCALE NTS	
DATE 6-26-08		SHEET 1 of 9	

[illegible]

 RED BARN MACHINE	
TITLE --	
DWG NO. --	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE NTS	DATE 8-15-07
SHEET 1 of 1	

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY: PERRITT	<div>RB</div> RED BARN MACHINE		
CHECKED	TITLE		
HEAT TREAT FINISH SPEC	TITLE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1	DWG NO. PART #		REV.
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE NTS	DATE 1-28-06	SHEET 1 of 1

USED ON MODEL
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